

Date: Thursday, 5/4/2006 10:46:22 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 26972	
Estimate Number : 10530	
P.O. Number : N/A	Part Number : D2571
This Issue : 5/4/2006 -S.O. No. : N/A	Drawing Number : D2571 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 26511	Material : N/A
Written By : <u>See Comment Rev</u>	Due Date : 5/25/2006 Qty: 12 Um: Each
Checked & Approved By : <u>06.05.04</u>	
Comment : Est: 10210.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571

Ensure that grain is along 7.75" length

Batch No: B24070 28

3 25205 x 4 Ep 06/05/10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 36972 Double check by: SA

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

J.G / Ep 06/05/11 (12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

J.G / Ep 06/05/16 (12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G / Ep 06/05/16 (12)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 24/05/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 5/4/2006 10:46:22 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 26972

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06/05/17 12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

A.M. 06-05-18

(12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/05/23

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

A.M. 06-05-23

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location

51478

SA

06/05/24

(12)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/05/25

(12)

Job Completion



C 206065/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 26972
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.746	1.747	1.745	1.746		
C	3.495	3.505		3.498	3.498	3.498	3.498		
D	1.745	1.755		1.746	1.747	1.745	1.746		
E	7.990	8.010		8.002	8.006	8.002	8.004		
F	0.490	0.510		0.490	0.499	0.499	0.498		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.497	0.497	0.497	0.498		
J	1.174	1.184		1.177	1.175	1.176	1.178		
K	0.558	0.578		0.562	0.562	0.563	0.561		
L	1.174	1.184		1.177	1.175	1.176	1.178		
M	1.490	1.500		1.494	1.492	1.493	1.494		
N	2.495	2.505		2.495	2.495	2.496	2.501		
O	3.869	3.879		3.870	3.870	3.872	3.873		
P	0.115	0.135		0.126	0.126	0.125	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.251	0.249	0.251		
S	0.115	0.135		0.127	0.120	0.126	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.238	0.233	0.237	0.238		
W	0.115	0.135		0.117	0.117	0.119	0.119		
X	0.308	0.313		0.311	0.311	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.368	0.367	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.625	0.627	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.241	0.246	0.243		
AE	1.375	1.395		1.387	1.390	1.385	1.388		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.253	0.250	0.249		
AI	2.000	2.020		2.001	2.002	2.000	2.002		
AJ	0.023	0.043		0.033	0.030	0.030	0.030		
Accept/Reject									

Measured by:	ES
Date:	06/05/14

Audited by:	MS
Date:	06/05/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 26972
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

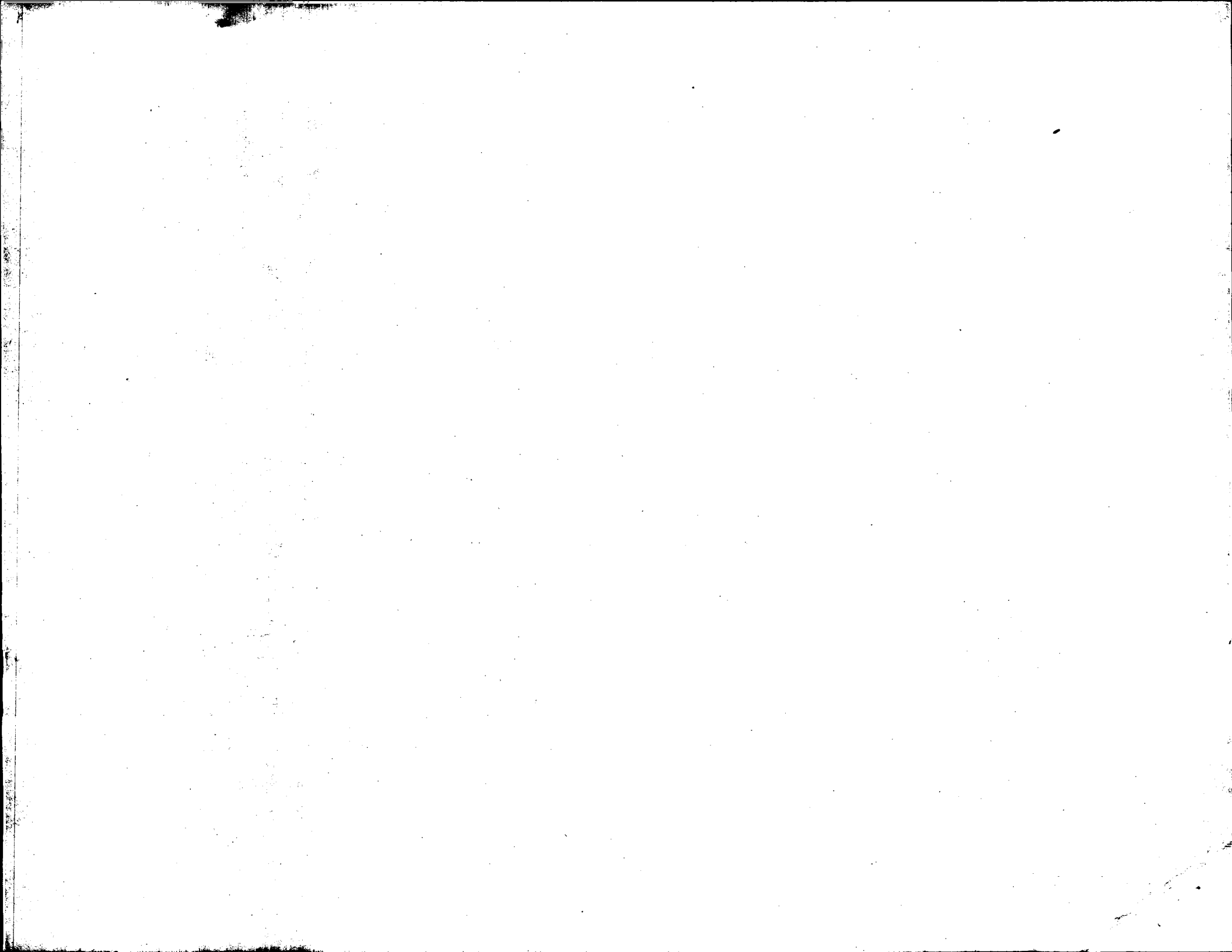
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B	1.745	1.755		1.746	1.748	1.748	1.745		
C	3.495	3.505		3.496	3.496	3.496	3.497		
D	1.745	1.755		1.746	1.748	1.748	1.745		
E	7.990	8.010		8.004	8.006	8.002	8.002		
F	0.490	0.510		0.496	0.495	0.493	0.500		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.498	0.498	0.501	0.496		
J	1.174	1.184		1.177	1.175	1.178	1.177		
K	0.558	0.578		0.560	0.563	0.565	0.566		
L	1.174	1.184		1.177	1.175	1.178	1.177		
M	1.490	1.500		1.494	1.495	1.493	1.494		
N	2.495	2.505		2.499	2.496	2.497	2.496		
O	3.869	3.879		3.870	3.870	3.873	3.873		
P	0.115	0.135		0.126	0.127	0.127	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.252	0.252	0.253		
S	0.115	0.135		0.125	0.126	0.125	0.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.966		
V	0.230	0.250		0.235	0.241	0.237	0.240		
W	0.115	0.135		0.120	0.124	0.117	0.117		
X	0.308	0.313		0.309	0.309	0.310	0.309		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.363	0.360	0.369	0.371		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.626	0.626	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.248	0.247	0.244		
AE	1.375	1.395		1.387	1.387	1.386	1.388		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.247	0.252	0.247	0.250		
AI	2.000	2.020		2.002	2.001	2.000	2.002		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by: EP
Date: 06/05/15

Audited by: MS
Date: 06/05/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



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C	3.495	3.505		3.497	3.499	3.499	3.497		
D	1.745	1.755		1.746	1.750	1.749	1.750		
E	7.990	8.010		8.004	8.003	8.003	8.003		
F	0.490	0.510		0.494	0.502	0.501	0.501		
G	0.257	0.262	DT8683	0.257	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.502	0.500	0.500	0.501		
J	1.174	1.184		1.178	1.180	1.179	1.180		
K	0.558	0.578		0.560	0.569	0.568	0.567		
L	1.174	1.184		1.178	1.180	1.180	1.180		
M	1.490	1.500		1.494	1.498	1.498	1.497		
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Q	0.115	0.135		0.135	0.125	0.135	0.135		
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U	2.940	2.980		2.960	2.960	2.966	2.960		
V	0.230	0.250		0.234	0.238	0.239	0.240		
W	0.115	0.135		0.119	0.117	0.118	0.118		
X	0.308	0.313		0.311	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.365	0.364	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.629	0.630	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.248	0.247	0.248		
AE	1.375	1.395		1.389	1.387	1.386	1.389		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.251	0.252	0.252	0.253		
AI	2.000	2.020		2.004	2.002	2.003	2.004		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	En / J.C
Date:	06/05/16

Audited by:	M8
Date:	06/05/17

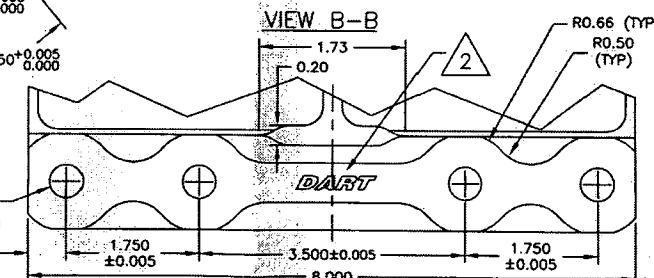
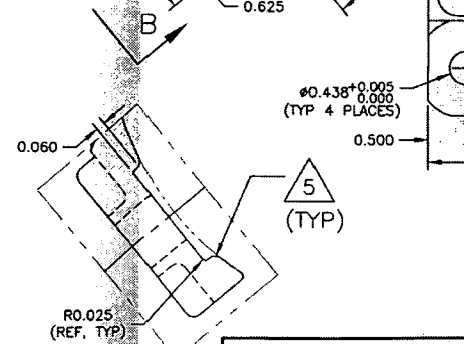
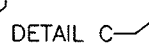
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A		New Issue	RF	
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




05.12.06 

MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |  |
|---|--|
| 1 | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
| 2 | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125       |
| 3 | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
| 4 | CHAMFER 0.063" x 45° ALL AROUND                                  |
| 5 | CHAMFER 0.033" x 45° (SEE DETAIL C)                              |



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
CHECKED 		APPROVED 
DATE 05.07.13		 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA DRAWING NO. D2571 TITLE OUTER FWD SADDLE
		REV. SHEET 1 OF SCALE

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DETAIL C  
SCALE 4:3

SHOP COPY  
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WITHOUT NOTICE

WORK ORDER  
NO. 26972